

Work Order ID 85189

Monday, June 04, 2012 1:14:55 PM

85189

ASAP

Item ID: PB67-43001-71

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: PB67-43001-71

Stop

NS2

Start Date: 6/4/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *unc*

Date: *12-08-04*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-71

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001-159

Dwg Rev: *C*

Prog Rev: *C*

****grain direction along 5.750"****

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(2)

12-6-6

(2)

JM 12-6-6

(2)

JM 12-6-6

Date

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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2

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

1- countersink as per dwg

2- Bend as per Dwg B67-43001

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 85189***85189***

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Monday, June 04, 2012 1:14:55 PM

Item ID: PB67-43001-71

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N900040100

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NS1

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Stop

NS2

Item Name: PB67-43001-71

Start Date: 6/4/2012 Start Qty: 2.00

2

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Required Date: 6/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

I- weld as per dwg B67-43001

2

0

ll
12-06-13

160

0.00

160

Small Fab

Small Fab

Memo

0.00

Small Fab

I-grind weld flush

2

0

ll
12-06-13

170

0.00

170

QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

2

0

BE 12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

Item Name: PB67-43001-71

Start Date: 6/4/2012 Start Qty: 2.00

Required Date: 6/15/2012 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

190

190

Small Fab

Small Fab

Small Fab

Memo

1-install nut plates as per dwg B67-43001

0.00

0.00

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

85189

Page 4

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

2

12/06/13

2

12/06/13

2

12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 6/4/2012 Start Qty: 2.00

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Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

6/4/12

12/6/14

MF
12-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 04, 2012 1:14:54 PM

Page 1

Work Order ID: 85189

Parent Item: PB67-43001-71

Parent Item Name: PB67-43001-71

Start Date: 6/4/2012

Required Date: 6/15/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec
IPP Rev:B 08-06-27 procedure chg DD verified by:EC
dwg EC verified by:DD
IPP rev C 10.09.30 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090 6061-T6 .090 Sheet		Purchased	No			190	sf	79.3000	0.8185	1.7231579		2-6-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		79.3							
				109184		2							
				111382		77.3							
MS20426AD3-4 RIVET		Purchased	No			100	Each	3,000.0000	12	24		12-6-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3000							
				104374		382							
				110398		2618							
MS21075L3 Nutplate		Purchased	No			190	Each	91.0000	6	12		12-6-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		46							
				121090		46							
				ST303		1							
				120910		1							
				ST321		44							
				121825		44							

109184
111382

24

12

3
SM
12-6-6
12/06/13
12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

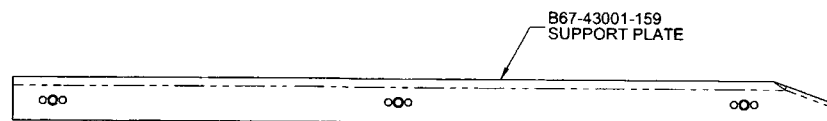
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

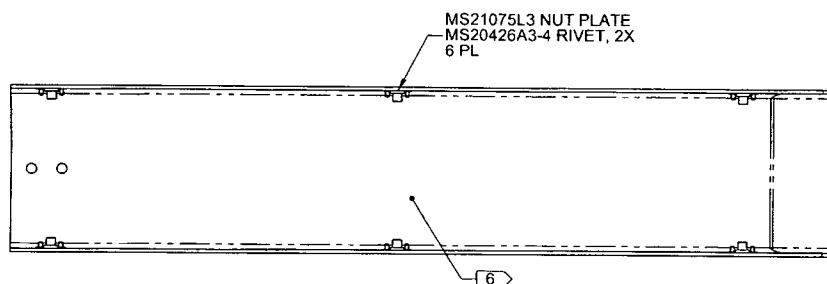
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -71	P/N	DESCRIPTION
1	X	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
2	1	B67-43001-159	SUPPORT PLATE
3	12	MS20426AD3-4	RIVET
4	6	MS21075L3	NUT PLATE



B67-43001-159
SUPPORT PLATE



MS21075L3 NUT PLATE
MS20426A3-4 RIVET, 2X
6 PL

B67-43001-71 20-DEGREE BLADE SUPPORT ASSY

85789

RELEASED
2010-09-16
WP

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-71" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.09 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	B			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	B67-43001-71		SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	N/A	20-DEGREE BLADE SUPPORT ASSY	NTS	
DATE	10.04.28	<small> COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>		

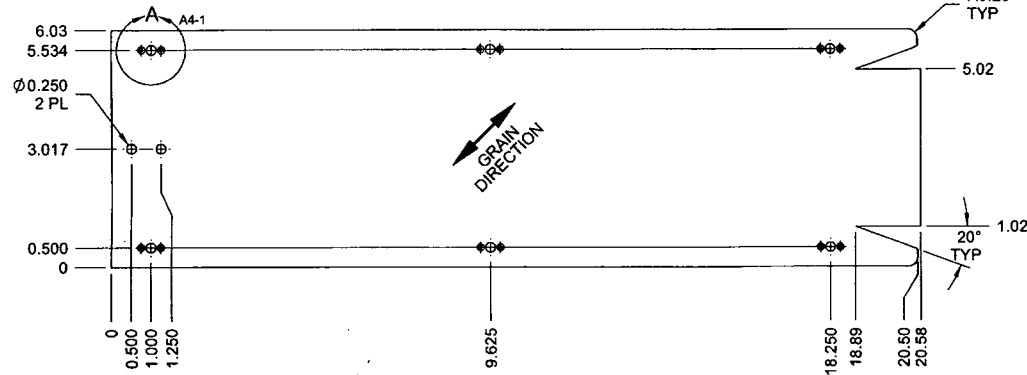
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

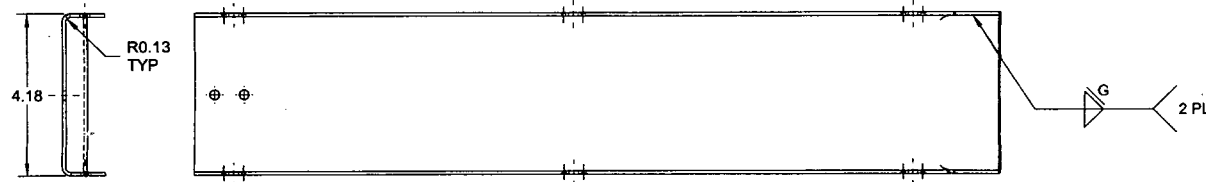
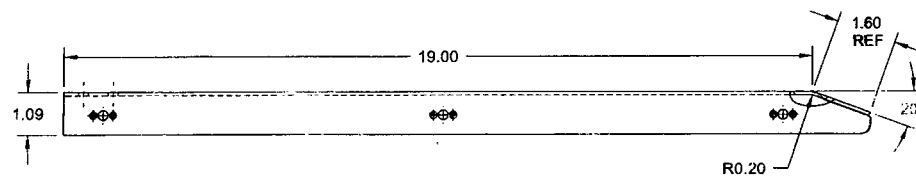
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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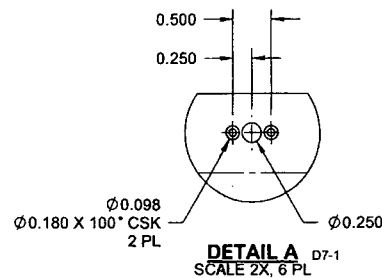
NOTE: Date & initial all entries



B67-43001-159F FLAT PATTERN



B67-43001-159 SUPPORT PLATE
(MAKE FROM B67-43001-159F)



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027 OR ASTM B209
REF. DART SPEC. M6061T6S.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 26 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
	REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ls			
CHECKED	MP	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-159	SHEET 1 OF 1	
APPROVED	MP	TITLE	SCALE	
DE APPR.	N/A	SUPPORT PLATE	NTS	
DATE	10.04.27	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

RELEASED
2010-09-16
MP

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DART AEROSPACE LTD		Work Order: 85189
Description: PB6743001-71		Part Number: PB6743001-71
Inspection Dwg:	Rev: C	Page 1 of 1

PB 6743001-159

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+0.004 - .001	100.098	2		V R02	mmol
Ø .750	+0.005 - .001	753.220	2		V	mmol
.250	±.010	.250	2		V	mmol
.500	±.010	.501	2		V	mmol
.500	±.010	1.500.504	2		V	mmol
3.017	±.010	3.022	✓		V	mmol
5.534	±.010	5.539	✓		V	mmol
6.03	±.030	6.043	✓		V	mmol
1.500	±.010	1.500.506	2		V	mmol
1.006	±.010	1.004	2		V	mmol
1.25	±.010	1.249.255	2		V	mmol
9.625	±.010	9.626"	✓		PROWZ02	m
18.25	±.010	18.250"	✓		AT1B01	H3-01
18.84	±.030	18.84"	✓		T	H3-01
20.50	±.030	20.50"	✓		T	H3-01
20.58	±.030	20.58"	✓		T	H3-01
1.02	±.030	1.026"	✓		V	mmol
5.02	±.030	5.023	✓		V	mmol
.090	±.010	0.88"	✓		V	mmol

Measured by: JB / JM	Audited by: S	Prototype Approval:	N/A
Date: 12-6-86	Date: 12/6/87	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

